



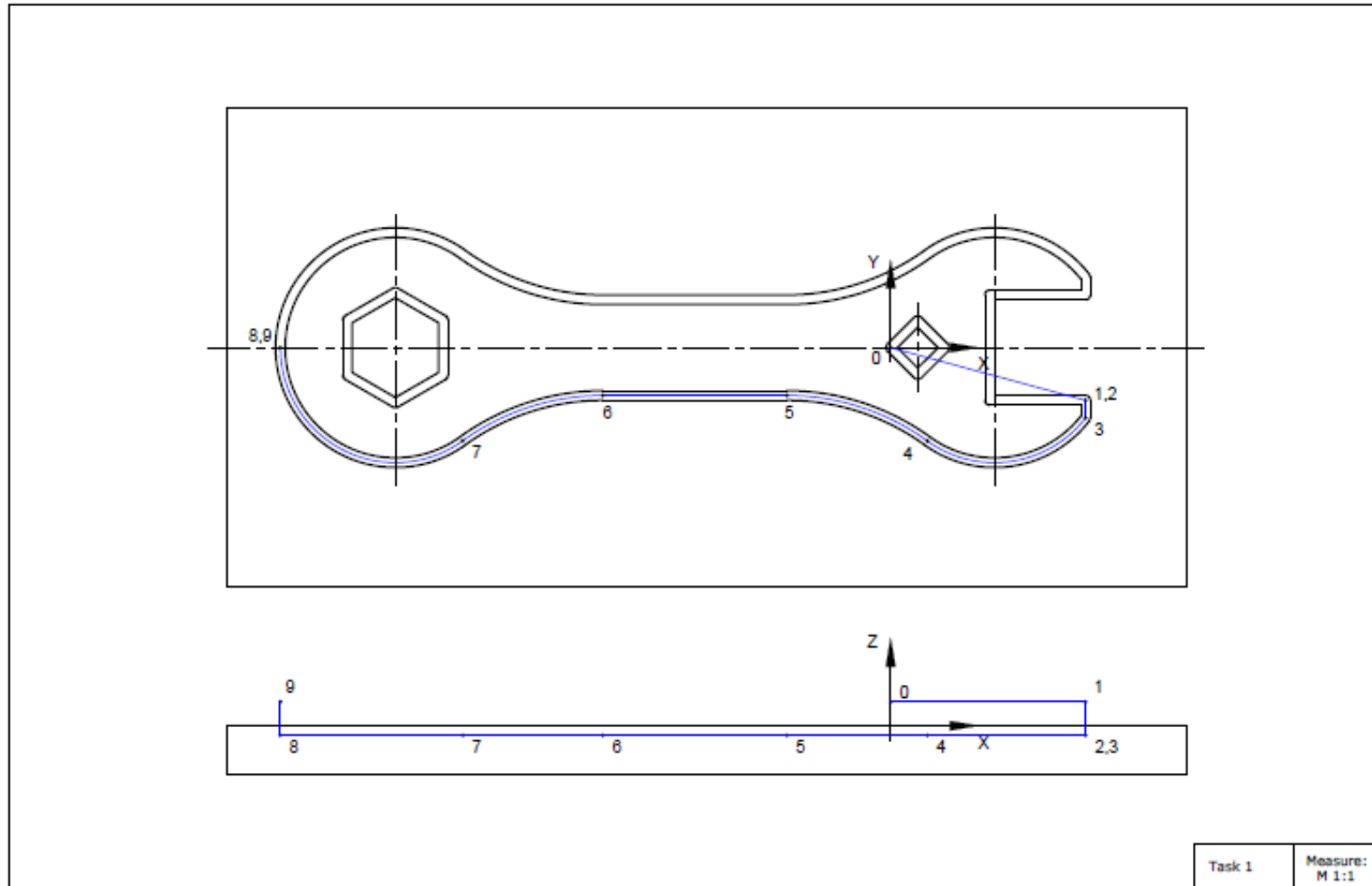
Field of education:
Mechanical engineering

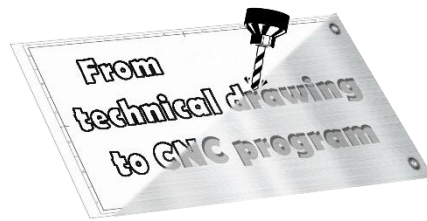
Professional qualification:
CNC operator

Exercise:
**Programming of CNC machine
(solution)**

Variant:
Task 9 – Wrench 3.3.

Solution:





Required written code that should be inserted into the control unit:

G0 X40,657 Y-11

G1 Z-2

Y-14,663

G2 X7,609 Y-19,459 R24

G3 X-21,656 Y-10 R50

G1 X-60,03

G3 X-89,296 Y-19,459 R50

G2 X-127,343 Y0 R24

G1 Z5

M30

Explanation of the G-code:

%Setting the coordinate system x=0, y=0, z=5; point 0

G0 X40,657 Y-11 %Positioning at the starting point; point 1

G1 Z-2 %Tool entry into material; point 2

Y-14,663 %Straight milling; point 3

G2 X7,609 Y-19,459 R24 %Radial milling; point 4

G3 X-21,656 Y-10 R50 %Radial milling; point 5

G1 X-60,03 %Straight milling; point 6

G3 X-89,296 Y-19,459 R50 %Radial milling; point 7

G2 X-127,343 Y0 R24 %Radial milling; point 8

G1 Z5 %Lifting of tool; point 9

M30 %End of program